

**Work Order ID 67018**

Thursday, March 03, 2011 11:53:08 AM



Page 1

Item ID: D3315-6

Accept



Setup Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 3/3/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 3/7/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:



Date: 11-03-3

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr	Revision Nbr
D3315	Rev B

100



FLOW WATER JET

Waterjet

Memo

0.00

111-3-7

FLOW CNC Waterjet

1010 .063

1-Cut as per Dwg D3315  
 Dwg Rev: B  
 Prog Rev: B  
 2-Deburr if necessary

6

110



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

1011-3-7

Quality Control

120



QC8- Inspect parts - second check

QC

Memo

0.00

S 103/08

Quality Control

76

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Reference:

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Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

130

Operation  
Description

NC BRAKE

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Brake NC

Brake NC

Memo

1- Form using DT8751 Die as per Dwg D3315Rev: B  
2- Form using DT8179 Die and DT8157 as per Dwg D3315 Rev: B

SB 11/03/09

(6)

140



QC6- Inspect dimensions to drawing

0.00

QC

Quality Control

Memo

0.00

5/11/09

(4)

150



Large Fab

0.00

Large Fab

Large Fab

Memo

Weld hard surface using D3315-6T3 as per QSI 004 and Dwg D3315 Rev: BQty Part Number Description Batch  
A/R N/A 7560 Hardcoat Rod M116772

(2)

11-3-16

(X6)

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



QC10- Inspect visual per QSI004- ground welds

0.00

8ul03/17

QC

Memo

0.00

Quality Control

170



QC5- Inspect part completeness to step on W/O

0.00

8ul03/17

QC

Memo

0.00

Quality Control

180



Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

0.00

Powdercoat

M 115108  
Memo11:50  
3200  
12:00

Powder Coating

START TIME:  
OVEN TEMPERATURE:  
FINISH TIME:

X6

6 BL 11-3-A

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC3- Inspect Part Finish

0.00

6 6 11/03/11



QC

Memo

0.00

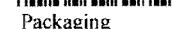
Quality Control

200

Packaging

0.00

11/3/17 6x



Packaging

Memo

0.00

Packaging

Identify on inside surface using a permanent fine point marker with the following:

TCCA-PDA, Dart Aerospace Ltd.

P/N: D3315-6, B/N: BXXXXX

For Product Eligibility see PDA04-17

and Stock

Location: 496A

210

QC21- Final Inspection - Work Order Release

0.00

11/3/17 6x



QC

Memo

0.00

Quality Control

11/03/17 6x

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	67068
Description: Wearplate		Part Number:	D3315-6
Inspection Dwg: D3315	Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article  Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
34.31	+/-0.030	34.31	X		T (B01)	
30.215	+/-0.010	30.215	X		T	
24.215	+/-0.010	24.215	X		T	
21.611	+/-0.010	21.611	X		T	
17.965	+/-0.010	17.965	X		T	
16.026	+/-0.010	16.026	X		T	
14.735	+/-0.010	14.735	X		T	
12.815	+/-0.010	12.815	X		T	
6.465	+/-0.010	6.465	X		V (B02)	
5.464	+/-0.010	5.466	*		✓	
4.527	+/-0.010	4.523	*		V	
3.550	+/-0.010	3.559	*		V	
5.214	+/-0.010	5.211	*		V	
Ø0.300	+0.006/-0.001	303	*		✓	
Ø0.266 x 0.575	+/-0.010	267x.580	*		✓	
Ø0.266 x 0.450	+/-0.010	267x.453	*		V	

Measured by:	B
Date:	11-3-1

Audited by:	D
Date:	11/03/08

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.22	New Issue	KJ/EC/DD	D

W/O:		WORK ORDER CHANGES					
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

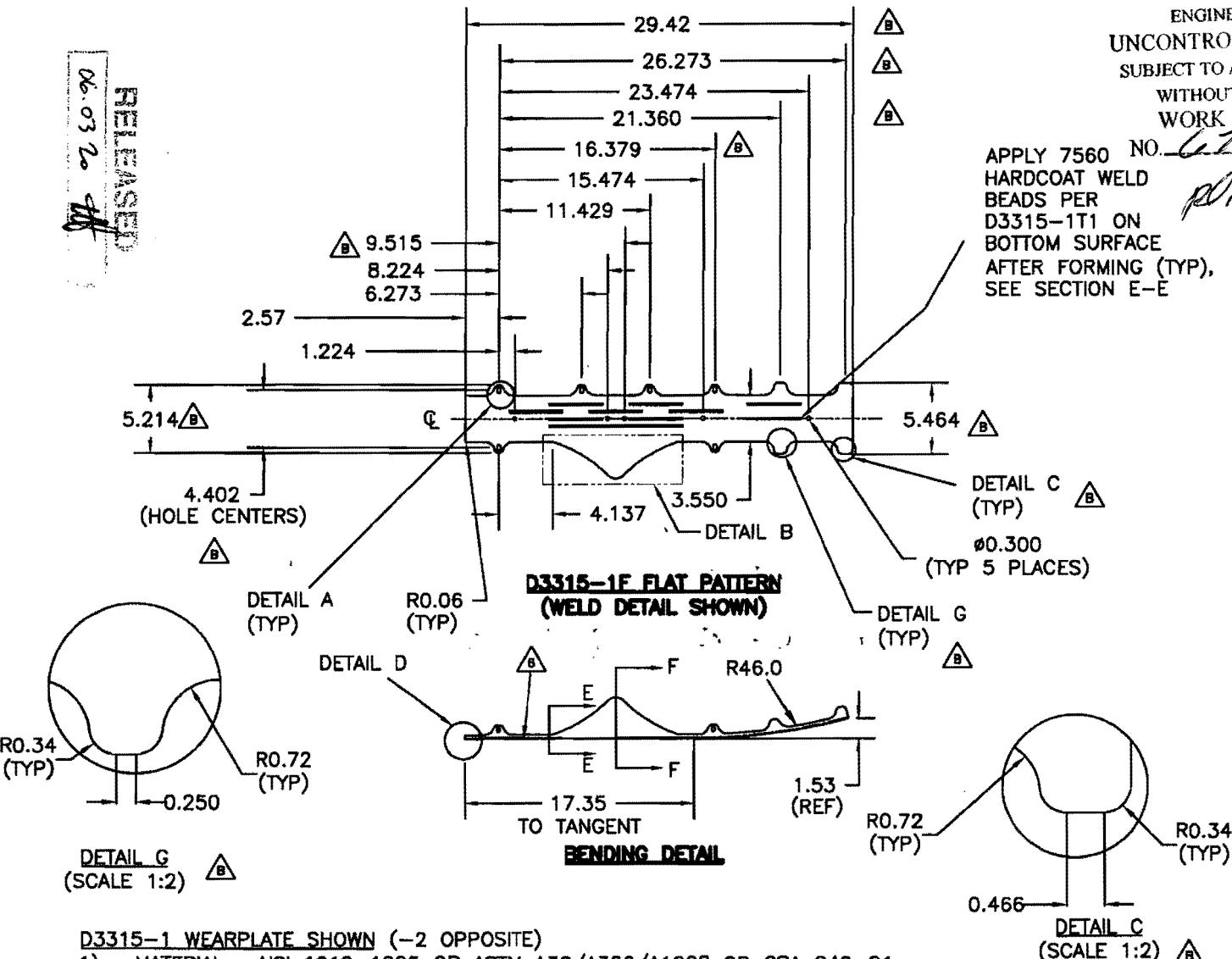
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER  
NO. 67018

**DART**



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
		DRAWING NO. D3315
DATE 06.01.31		REV. B
A	04.09.10	NEW ISSUE
B	06.01.31	UPDATE DIMENSIONS
		SCALE 1:12

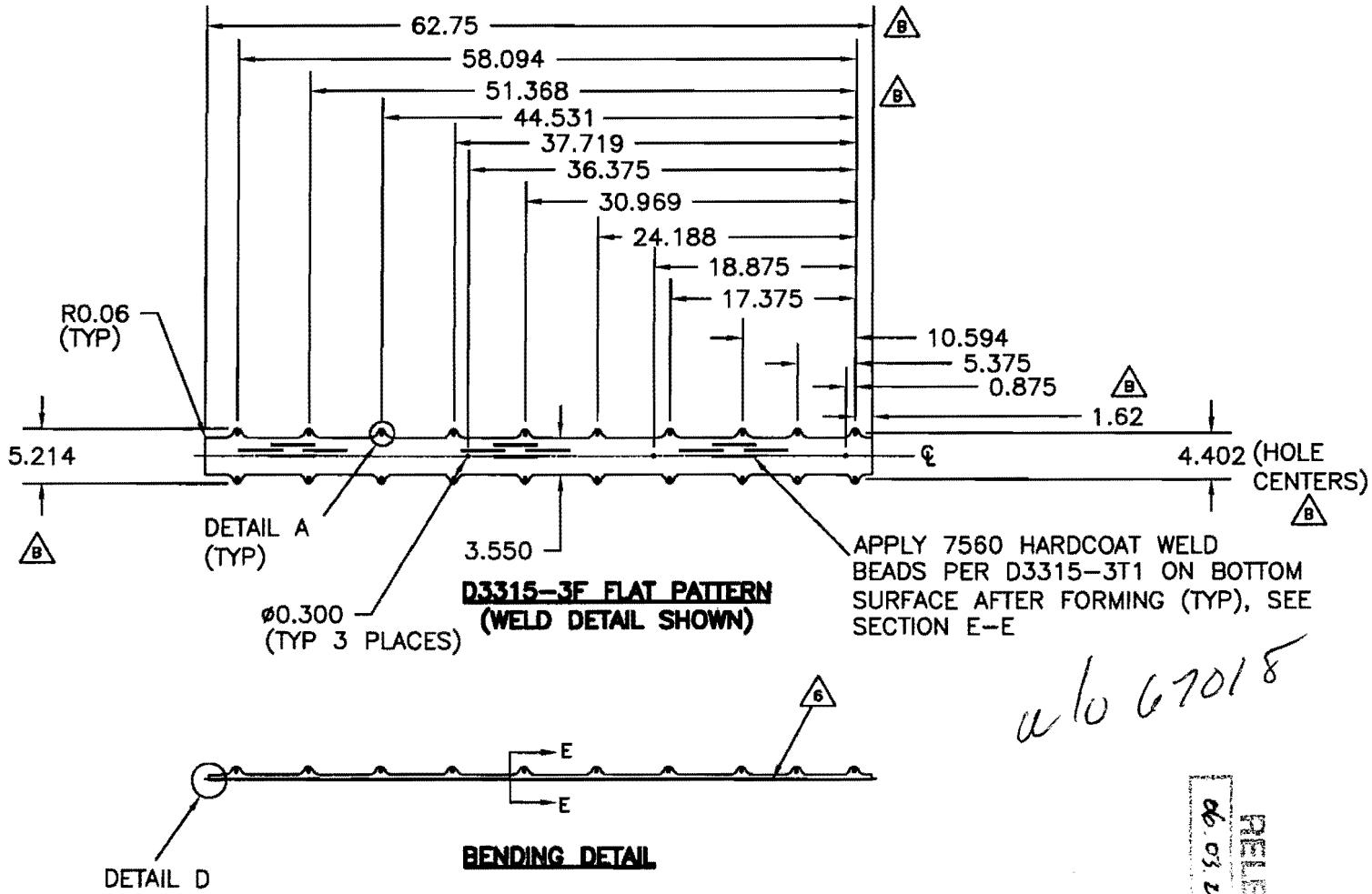
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries



**D3315-3 WEARPLATE SHOWN (-4 OPPOSITE)**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED

"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X  
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

**DART**

DESIGN PH	DRAWN BY PH	<b>DART AEROSPACE LTD</b>	
CHECKED	APPROVED	DRAWING NO.	HAWKESBURY, ONTARIO, CANADA
		D3315	REV. B
DATE 06.01.31		TITLE WEARPLATE	SHEET 2 OF 4
		SCALE 1:16	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

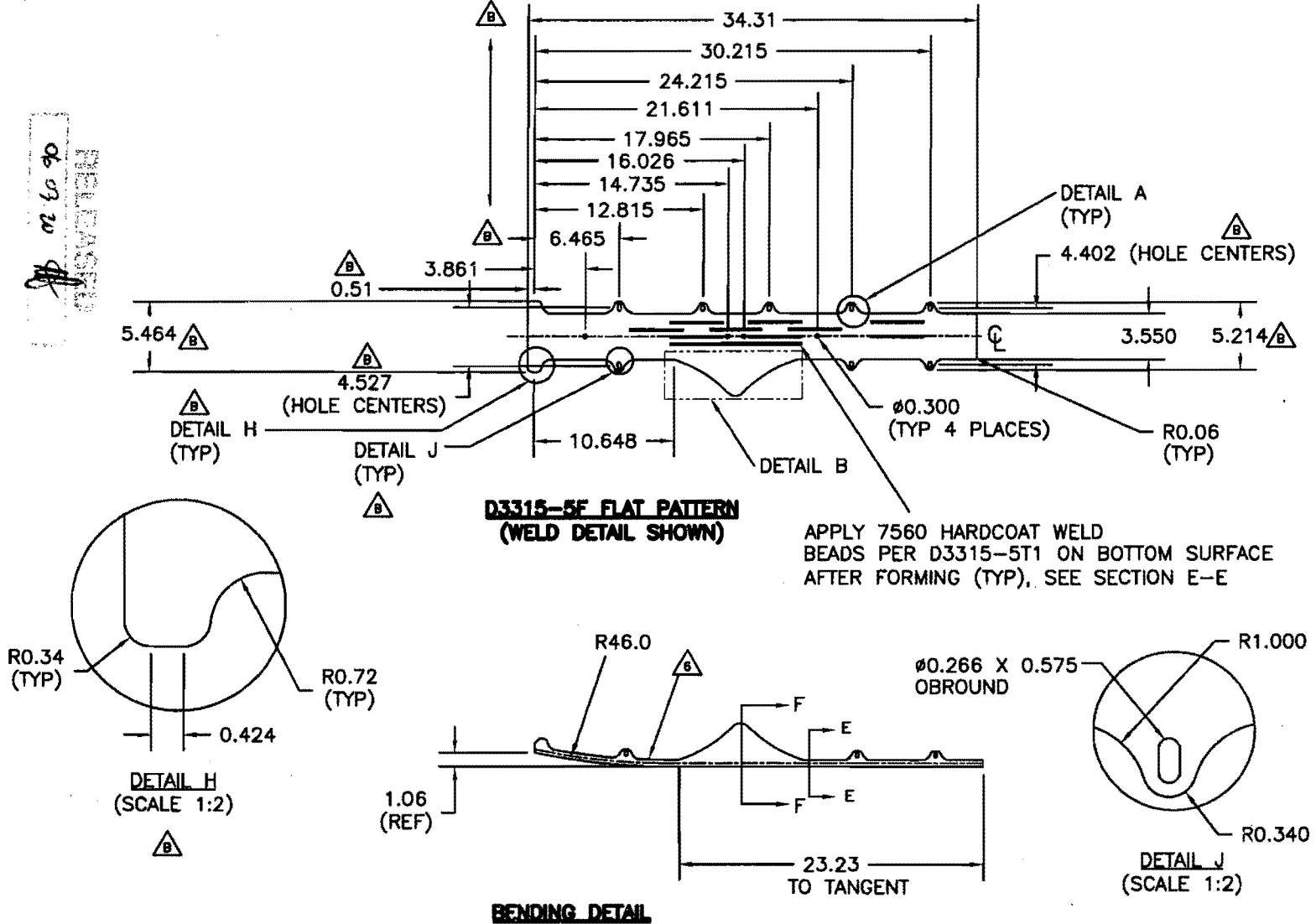
**DART**

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD	
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA	
DATE 06.01.31		DRAWING NO. D3315	REV. B
		TITLE WEARPLATE	SCALE 1:12
			1

RELEASER  
06.07.00

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**D3315-5 WEARPLATE SHOWN (-6 OPPOSITE)**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSION ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED

"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X  
B/N BXxxxx, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

w/v 47018

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

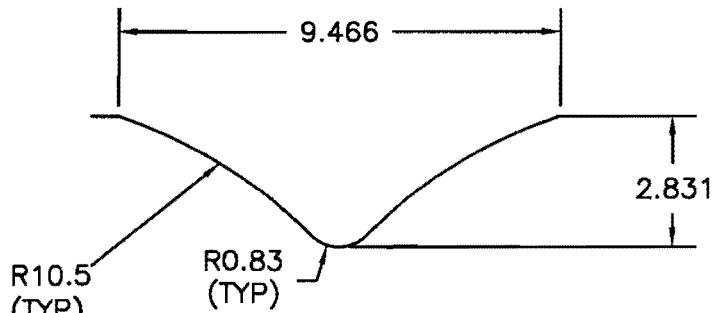
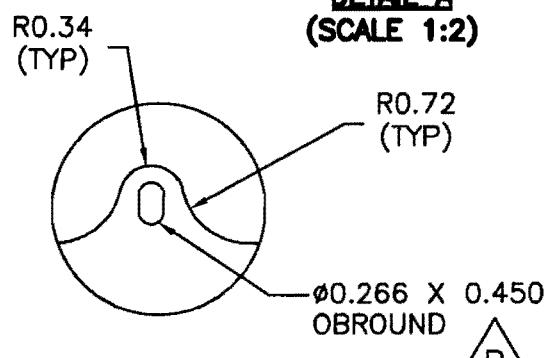
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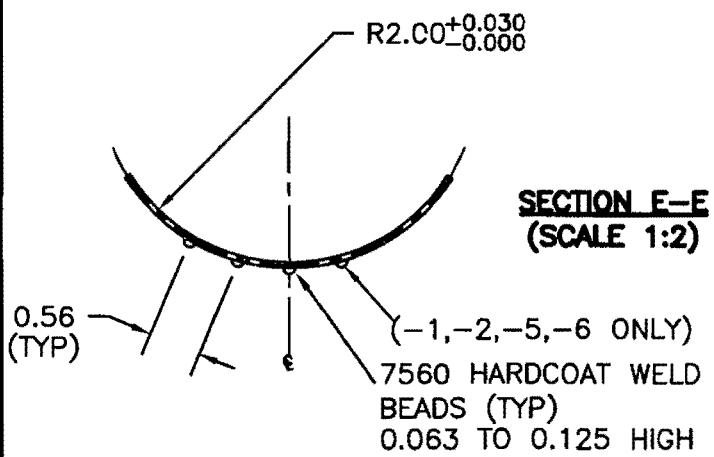
**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD
P4	P4	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
DATE	06.01.31	REV. B
		D3315
		NTS
		SCALE

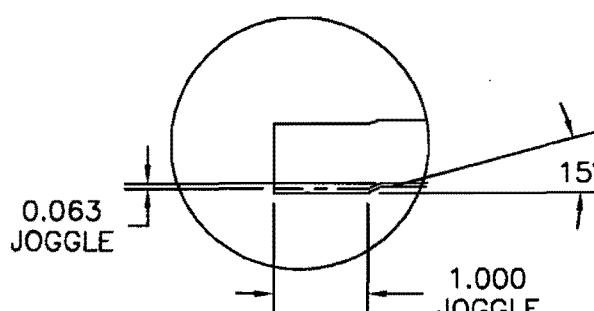
**DETAIL A**  
(SCALE 1:2)



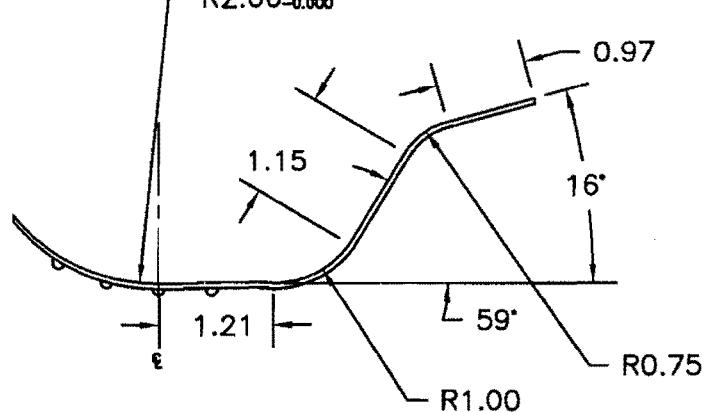
**DETAIL B**  
(SCALE 1:4)



**SECTION E-E**  
(SCALE 1:2)



**DETAIL D**  
(SCALE 1:2)



**SECTION F-F**  
(SCALE 1:2)

W/O:		WORK ORDER CHANGES					
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